



# Work Order ID 55896

February 4, 2010 8:31:33 AM


Page 1


Item ID: D4001-7 *Not D4001-3* Accept  Setup Start   
Revision ID: Stop   
Item Name: Fuel Filler Bulkhead Fitting  
Start Date: 2/04/10 Start Qty: 2.00  Cust Item ID:  
Required Date: 2/11/10 Req'd Qty: 2.00  Customer:  
Reference:


Approvals: Process Plan: *[Signature]* Date: 10-2-04 Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start   
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop 

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D4001	A- <i>PRELIM</i> <i>LAT</i> <i>Rev. A</i> <i>10-06-0</i>

100		0.00				2	<i>[Signature]</i>		
	Lathe Conv	0.00							
	Conventional Lathe								
	Memo								
	Turn fitting as per Dwg								
	Deburr								

110		0.00				2	<i>[Signature]</i>		
	QC	0.00							
	Quality Control								
	Memo								
	QC2- Inspect parts off machine FAI/FAIB								

120		0.00							
	QC	0.00							
	Quality Control								
	Memo								
	QC8- Inspect parts - second check								

**PRELIMINARY ISSUE**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Work Order ID 55896

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Page 2

Item ID:	D4001- <i>3</i>	Accept		Setup	Start	
Revision ID:					Stop	
Item Name:	Fuel Filler Bulkhead Fitting					
Start Date:	2/04/10	Start Qty:	2.00		Cust Item ID:	
Required Date:	2/11/10	Req'd Qty:	2.00		Customer:	
Reference:						

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 	Chemical Conversion Coat per QSI005 4.1	0.00							
HandFinish	Memo	0.00							
Hand Finishing	Brush alodine as per Dwg ***Scotch Brite machined surface prior to Alodine***								
140 	QC3- Inspect Part Finish	0.00							
QC	Memo	0.00							
Quality Control									
150 	Identify as per dwg & Stock Location: _____	0.00							
Packaging	Memo	0.00							
Packaging									

*BR 10-02-9*

*(2)*

*W 10-02-09*

*(2) 1*

*10-6-15" (2) sf*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



**Work Order ID 55896**


February 4, 2010 8:31:33 AM



Page 3

Item ID: D4001-*X3* Accept  Setup Start   
Revision ID: Stop   
Item Name: Fuel Filler Bulkhead Fitting  
Start Date: 2/04/10 Start Qty: 2.00  Cust Item ID:  
Required Date: 2/11/10 Req'd Qty: 2.00  Customer:  
Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start   
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop 

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160 	QC21- Final Inspection - Work Order Release	0.00							
QC Quality Control	Memo	0.00							

*10/06/15* *[Signature]*  
*10-219*  
*(2)*

POSITIVE RECALL  
EFFECTIVE *10-02-04* AUTH *[Signature]*  
RELEASED *[Signature]* DATE *10-06-10*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

February 4, 2010 8:31:37 AM

Page 1

Work Order ID: 55896

Parent Item:

D4001-*X 3*

Parent Item Name: Fuel Filler Bulkhead Fitting

Start Date: 2/04/10



Required Date: 2/11/10

Comments:

Ipp Rev:A New Issue 10-02-03 JLM Verified By:EC

Start Qty: 2.00

Required Qty: 2.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
AN832-6D  UNION		Purchased	No			100	Each	10.0000	2.1053 		<i>10-2-5 SP</i>	

## Warehouse

## Loc Qty

## Loc Code

### Location

Main Warehouse

ST

10

*107737*

9

16323

1

*2*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

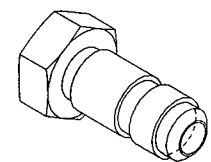
**NOTE:** Date & initial all entries



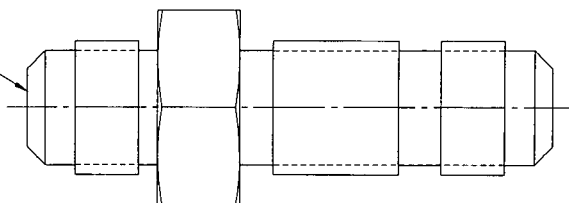


NO acct x2

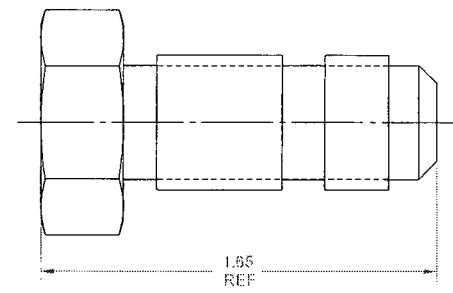
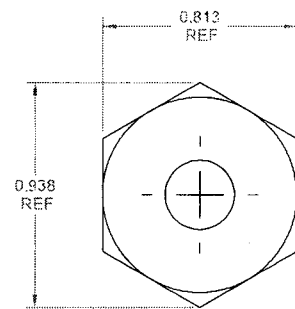
DART AEROSPACE PART NUMBER	JOHN CAMERON AVIATION PART NUMBER
D4001-7	JCA-M47-2-28 (AN832-6D-JCA)



AN832-6D  
BEFORE MODIFICATION  
REF



SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 35896  
BS 10-2-04



Route Done  
BOM Done

new - 3 of see rev. A  
D4001-7 FUEL FILLER BULKHEAD FITTING

PRELIMINARY ISSUE  
09.10.14

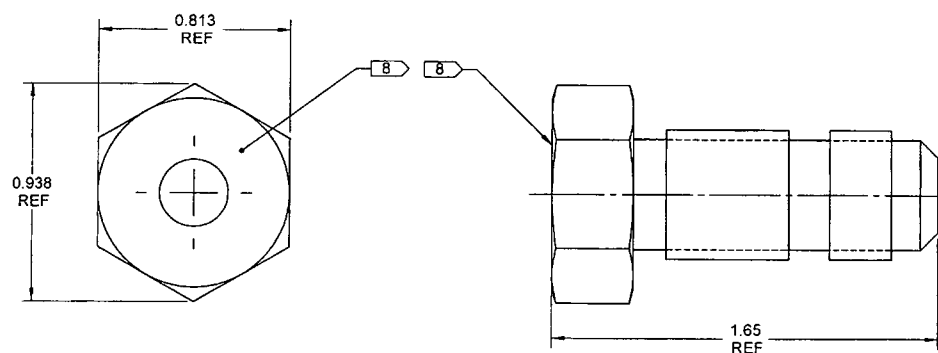
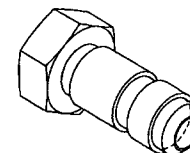
- NOTES:
- 1) MATERIAL: MADE FROM AN832-6D
  - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
  - 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4001-7" AND B/N USING FINE POINT PERMANENT INK MARKER
  - 7) WEIGHT: 0.04 lbs

DESIGN	DART AEROSPACE LTD	REV. PA1
DRAWN	HAWKESBURY, ONTARIO, CANADA	SHEET 2 OF 2
CHECKED	DRAWING NO. D4001	SCALE
MFG. APPR.	TITLE FITTING	NTS
APPROVED	DATE 09.10.14	
DE APPR.		

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DART AEROSPACE PART NUMBER	JOHN CAMERON AVIATION PART NUMBER
*D4001-3	JCA-M47-2-28 (AN832-6D-JCA)

AN832-6D  
BEFORE MODIFICATION  
REF



D4001-3 FITTING

WRO 55856

RELEASED  
2010-05-05

- NOTES:
- 1) MATERIAL: MADE FROM AN832-6D
  - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
  - 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4001-3" AND B/N USING FINE POINT PERMANENT INK MARKER
  - 7) WEIGHT: 0.04 lbs
  - 8) BRUSH ALODINE MACHINED SURFACE

DESIGN		<b>DART AEROSPACE LTD</b>	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D4001	SHEET 2 OF 2
APPROVED		TITLE	SCALE
DE APPR.		FITTING	NTS
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